

Work Order ID 151705

Friday, October 07, 2016 2:33:15 PM

151705

Page 1

Item ID: D4956-23

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Center Fwd

Start Date: 10/3/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/7/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: VSDate: 16/10/11

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4956

A

100

0.01

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

0.29

(8)

Dec 16/10/18

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.01

(8)

Dec 16/10/18

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151705

Page 4

Item ID: D4956-23 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Center Fwd
Start Date: 10/3/2016 Start Qty: 8.00 ***g*** Cust Item ID:
Required Date: 10/7/2016 Req'd Qty: 8.00 ***g*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180	QC21- Final Inspection - Work Order Release	0.00							
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180

QC

Memo

0.13

Quality Control

DAS
21
9-30

OCT 31 2016

DAS
21
9-30

OCT 31 2016

Picklist Print

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Page 1

Work Order ID: 151705

151705

Parent Item: D4956-23

D4956-23

Parent Item Name: Wearplate Center Fwd

Start Date: 10/3/2016

Required Date: 10/7/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

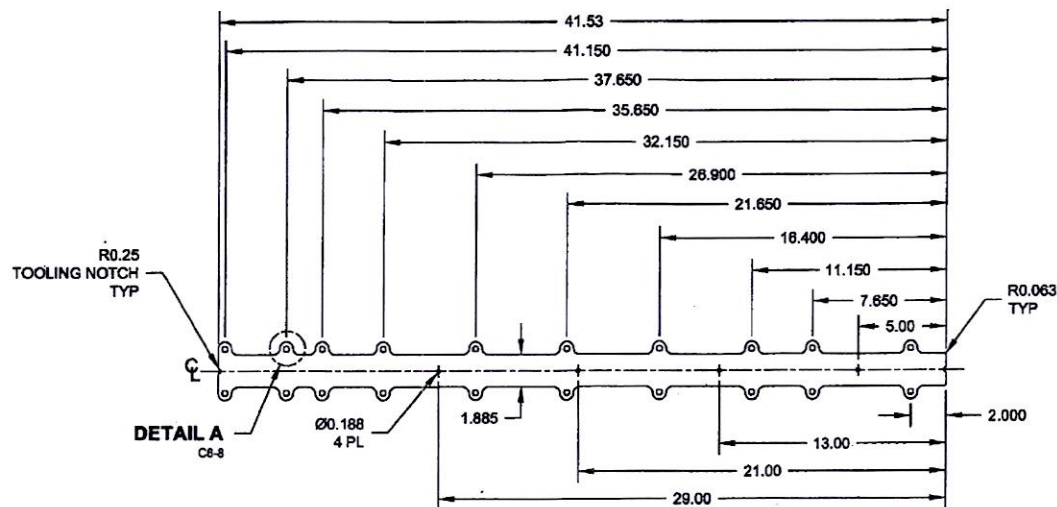
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No			sf	160.3210		10.52632			

M304S20GA

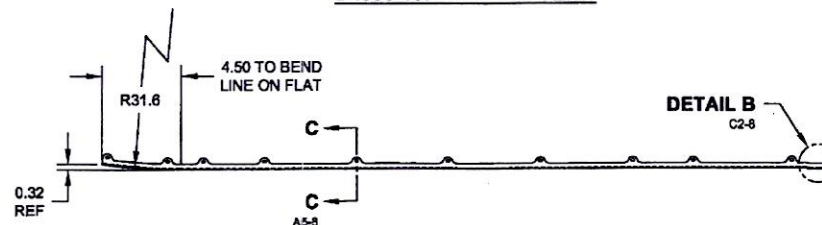
304/316 .040 Sheet

Done 10/10/18

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	158.1	
m134495	0.2	
m134982	0.1	
m135327	93.8	9.6
m135689	64	
MAT20	2.221	
m133901	2.221	



D4956-15F FLAT PATTERN



D4956-15 WEARSHOE
(MAKE FROM D4956-15F)

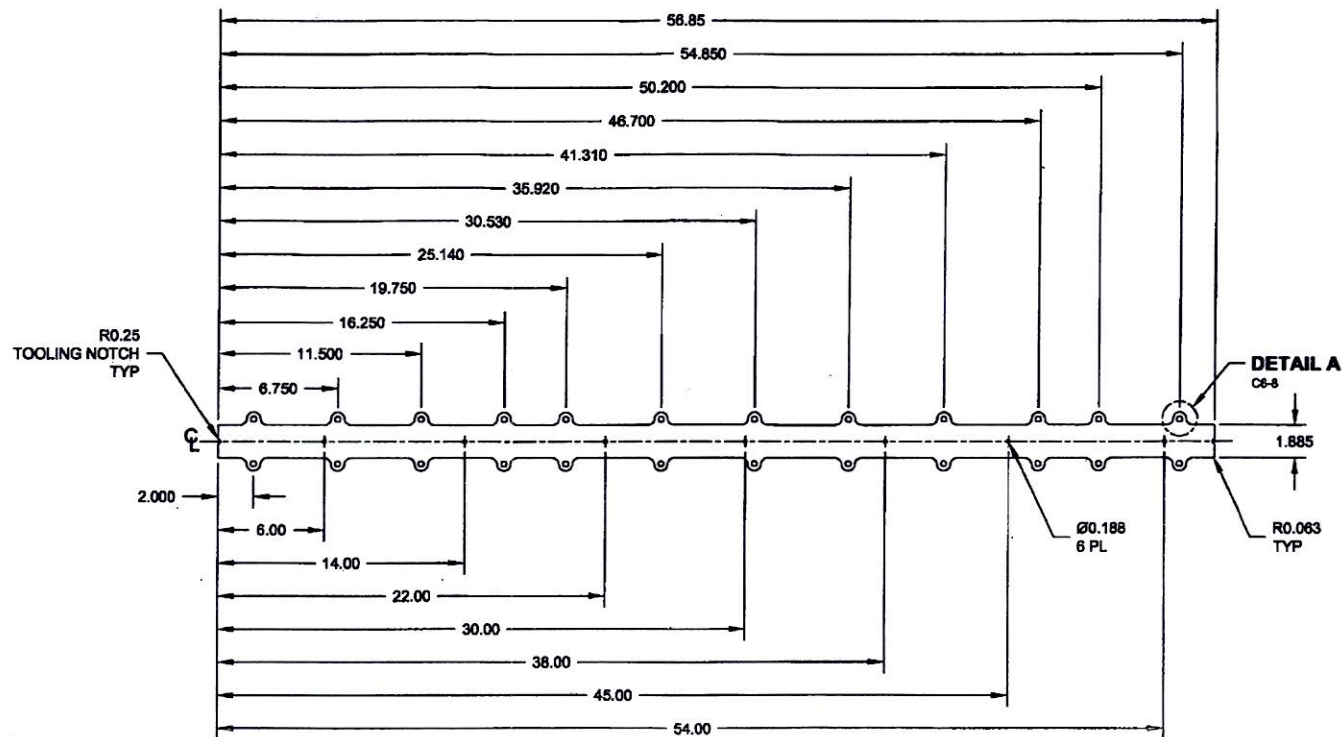
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151708 VLS
16/10/11

RELEASED
2014-04-17
MD

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.038 THICK (20 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.95 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	IS	D4956	SHEET 2 OF 8
APPROVED	149	TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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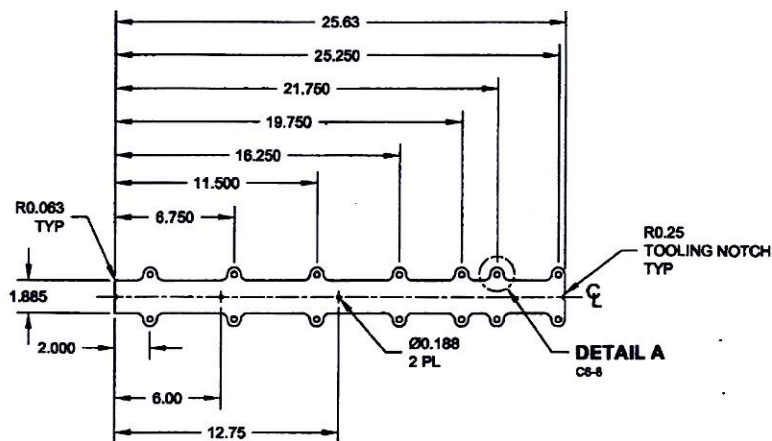


NOTES

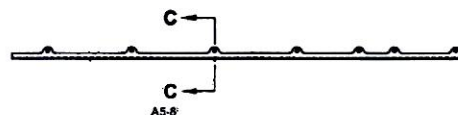
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.038 THICK (20 GAUGE)
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 1.29 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

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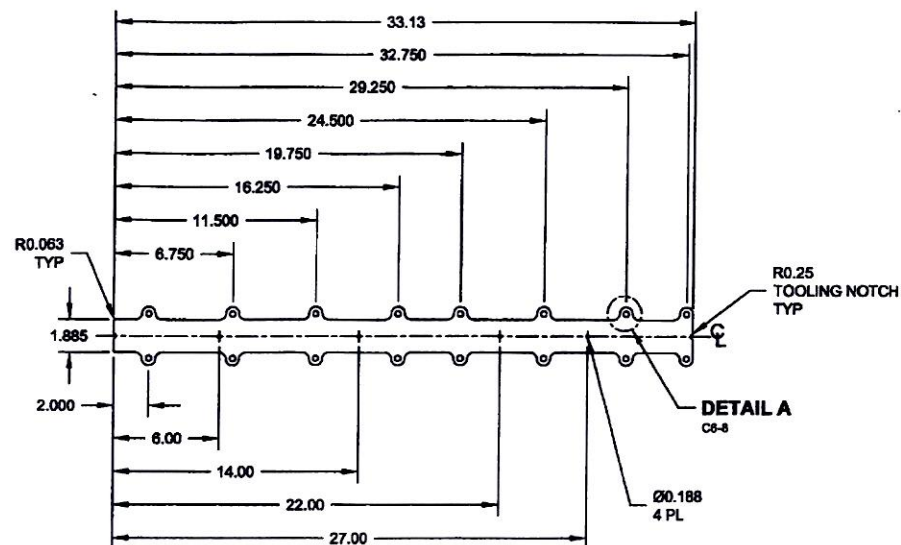
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2014-04-17
MP



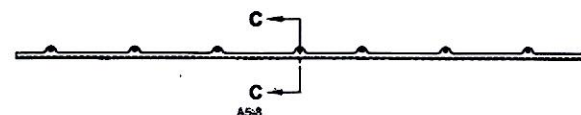
D4956-35F FLAT PATTERN



D4956-35 WEARSHOE
(MAKE FROM D4956-35F)



D4956-37F FLAT PATTERN



D4956-37 WEARSHOE
(MAKE FROM D4956-37F)

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.038 THICK (20 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4956-35 = 0.60 lbs; D4956-37 = 0.78 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

DESIGN	J	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	B	D4956	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.	JH	WEARSHOE	NT
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